

Date: Monday, 1/14/2008 2:32:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIVOT
Job Number : 36726	
Estimate Number : 11131	
P.O. Number :	Part Number : D31141
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D3114 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By : <u>KA 08 01 15</u>	Due Date : 2/10/2008 Qty: <u>20</u> Um: Each
Checked & Approved By : <u>KA 08 01 15</u>	
Comment : Est. A 02.05.30 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR
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(20)

Comment: Qty.: 0.0612 f(s)/Unit Total: 0.2449 f(s)

303 HEX BAR

Matl: AISI 303 Stainless steel 1/2" hexbar. (DART spec. M303H0.500)

B.A 08/01/25

Batch M106789

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(20)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA244

Deburr break all unmarked sharp edges .005 to 0.010

B.A / ml 08/01/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A / ml 08/01/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 08/01/25 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: S766

C 8/01/25 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT

Job Number: 36726

Part Number: D31141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/29

Job Completion



2008/1/28

(20x)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

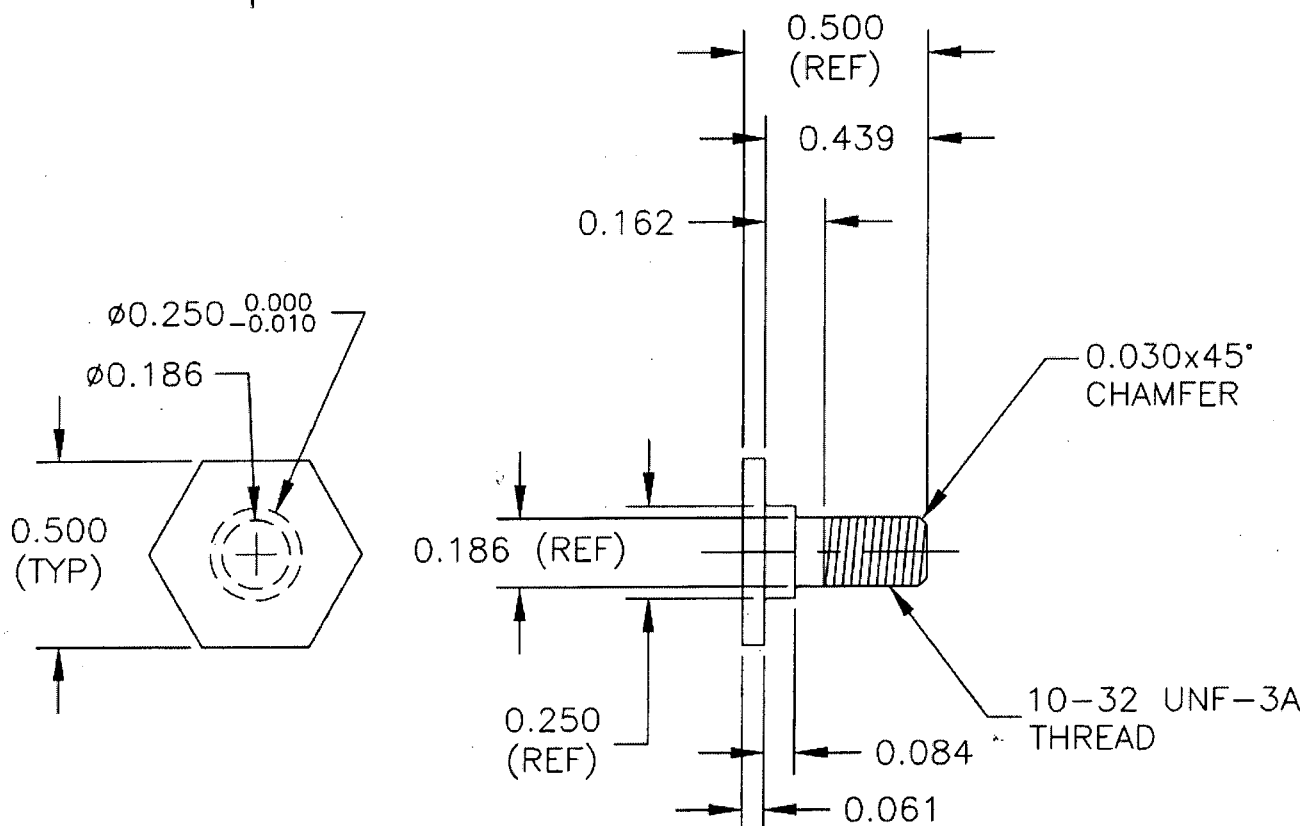
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3114 REV. B SHEET 1 OF 1
DATE	04.10.18	TITLE	PIVOT	SCALE 2:1
A	02.04.12	NEW ISSUE		
B	04.10.18	ADD PART MARKING; ADDED ANNEALED		

RELEASED
04.11.23



D3114-1 PIVOT

NOTES:

- 1) MATERIAL: ANNEALED AISI 303 STAINLESS STEEL 1/2" HEX BAR
(REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36726

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